

Work Order ID 73911

Monday, September 19, 2011 10:06:56 AM



Page 1

Item ID:	D3822-5KGY	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Vertical Tunnel, Top-Grey					
Start Date:	9/19/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	9/23/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>11-09-19</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
d3822-5	Rev C								

100		0.00							
	HandThermo	Memo							
	Hand Finishing Thermoforming	1-Cut Sheet to required Blank size				x2			<u>Wh</u> <u>11/17/21</u>

105		0.00							
	HandThermo	Memo							
	Hand Finishing Thermoforming	Dry Sheet as per QSI022 KYDEX							
		Temp: <u>150°F</u>							
		Time IN: <u>4:00 pm</u>	<u>11/17/20</u>						
		Time OUT: <u>2:00 am</u>	<u>11/17/21</u>						<u>Wh</u> <u>11/17/21</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3822-5KGY

Accept

Setup Start

Revision ID:

Stop

Item Name: Vertical Tunnel, Top-Grey

Start Date: 9/19/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 2.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110  Thermoform	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA028 using tool DT9078 Dwg Rev: <u>C</u> Folio Rev: <u>B</u>	0.00 0.00				x2			Wh 11/12/21
120  QC	QC2- Inspect parts off machine FAI/FAIB	0.00				x2			Wh 11/12/21
Quality Control	Memo Visually inspect part for proper formation and texture	0.00							
130  QC	QC8- Inspect parts - second check	0.00							
Quality Control	Memo	0.00							5 11/12/22

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Page 3

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Setup Start

Revision ID:

Stop

Item Name: Vertical Tunnel, Top-Grey

Start Date: 9/19/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

x2

Dh
11/12/22

150

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

x2

Dh
11/12/22

160

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

5 11/12/22

(72)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Item ID: D3822-5KGY

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Revision ID:

Stop



Item Name: Vertical Tunnel, Top-Grey

Start Date: 9/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: 150

0.00



Packaging

Memo

0.00

Packaging

11/12/22 20

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/12/28 20

11-12-23
6

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, September 19, 2011 10:06:53 AM

Page 1

Work Order ID: 73911



Parent Item: D3822-5KGY



Parent Item Name: Vertical Tunnel, Top-Grey

Start Date: 9/19/2011

Required Date: 9/23/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	436.3796	0.71	1.420710			



Kydex steel grey



Location

therm

Loc Qty

436.3796282

436.379628

Loc Code

119476

1.420710 sq ft

DL
11/12/22

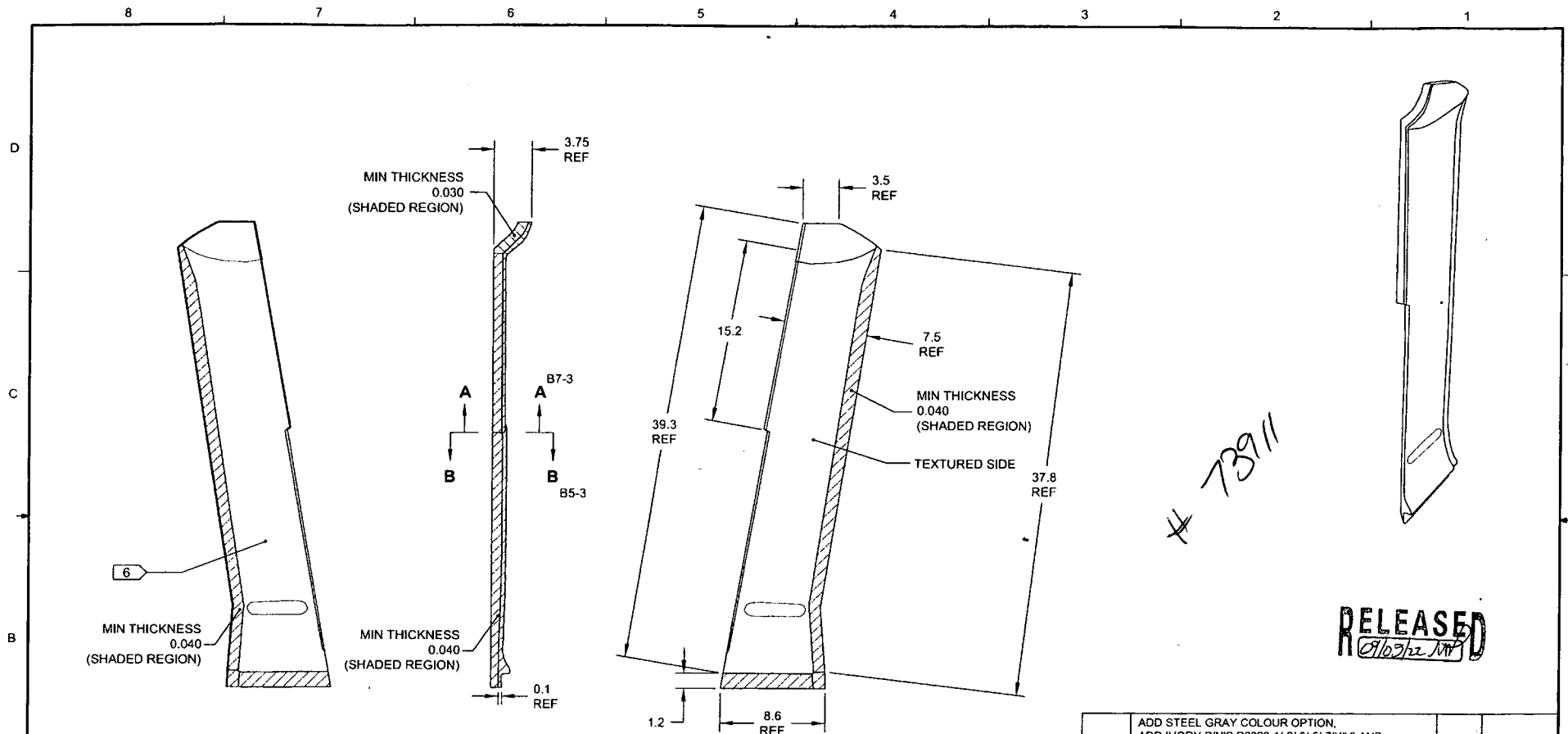
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3822-1 VERTICAL TUNNEL, LH
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9073 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION
D3822-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3822-1/-2/-3/-5/-7(KIV) AND ADD STEEL GRAY P/N'S D3822-1/-2/-3/-5/-7(KGY) (ZN A5-1, A5-2, A5-4, A5-5, A5-6)	PH	09.05.05
B	37.8 WAS 38.8 (ZN C8-4); MODIFY TOP OF -3 AND ADD VIEW J (ZN A3-4); INCREASE JOGGLE ON -3 (ZN C8-4); UPDATE VIEW F (ZN A1-4); REASON: TO IMPROVE FIT OF D206-781-151 KIT	PH	09.02.09
A	NEW ISSUE	PH	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. C D3822 SHEET 1 OF 6 TITLE SCALE VERTICAL TUNNEL (BELL 206 A/B) -NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	RA		
CHECKED	RA		
MFG. APPR.	RA		
APPROVED	RA		
DE APPR.	RA		
DATE	09.05.05		

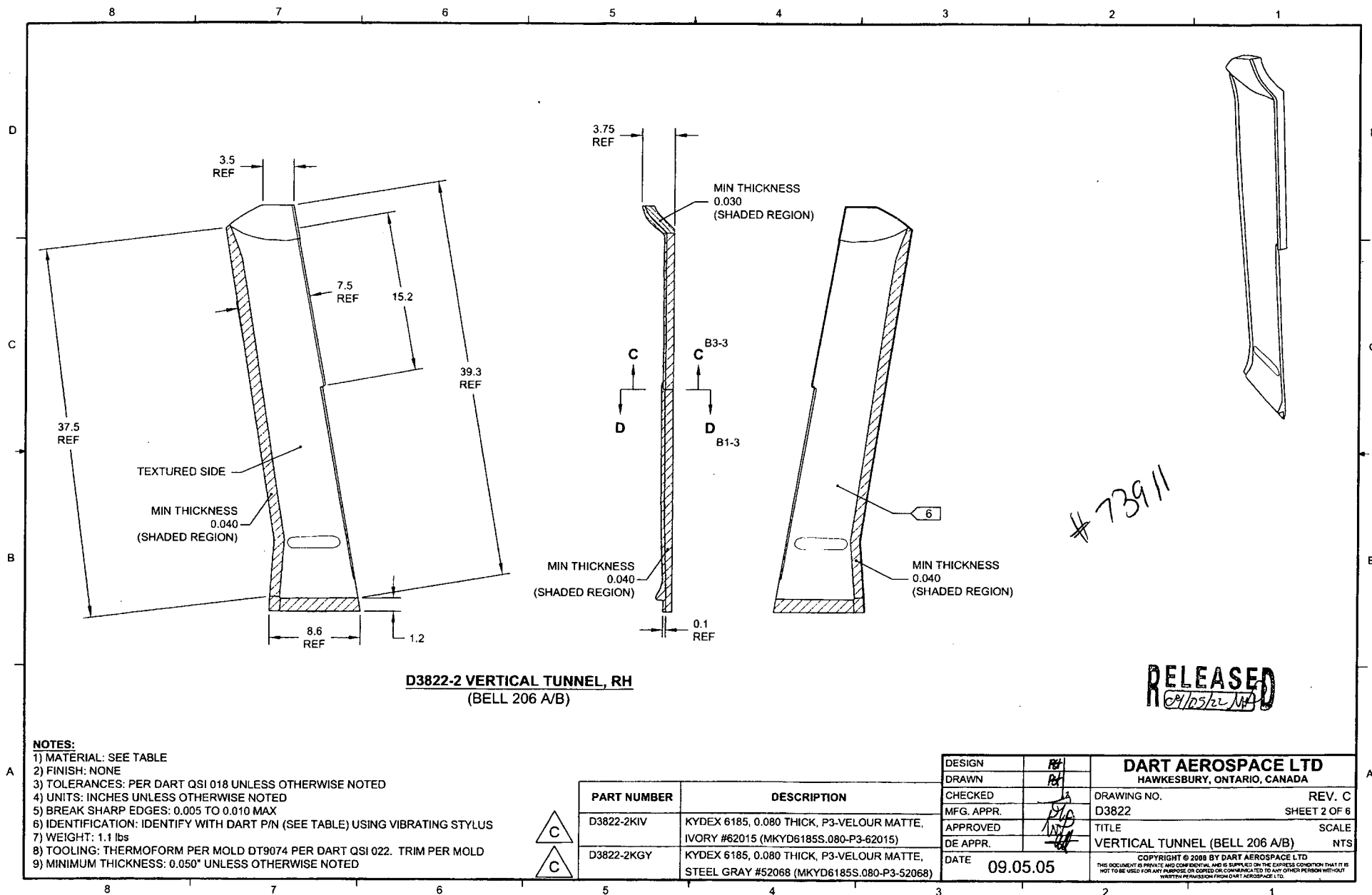
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



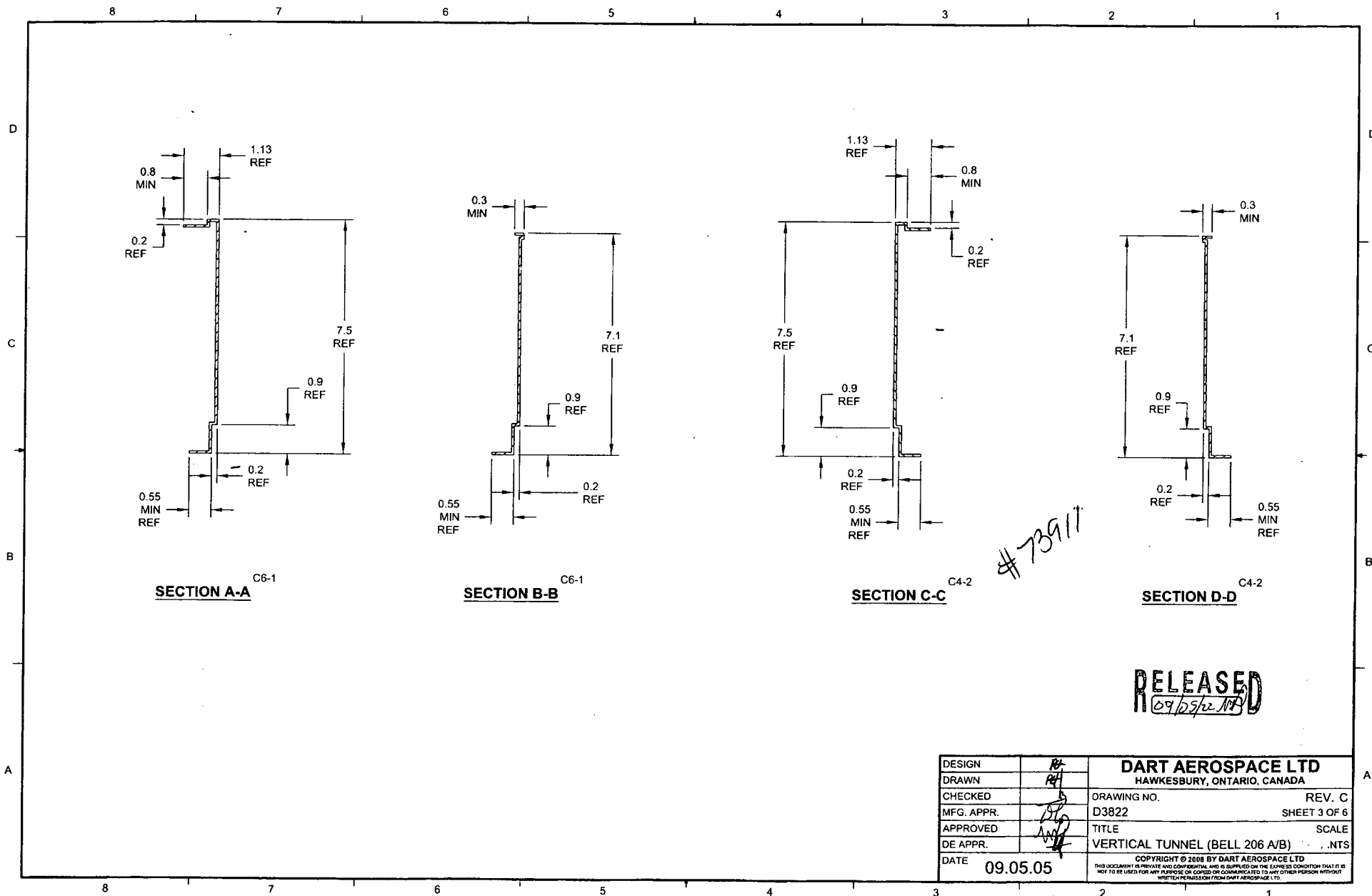
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
09/05/05

DESIGN	RA	DART AEROSPACE LTD	
DRAWN	RA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D3822	SHEET 3 OF 6
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	VERTICAL TUNNEL (BELL 206 A/B)	NTS
DATE	09.05.05	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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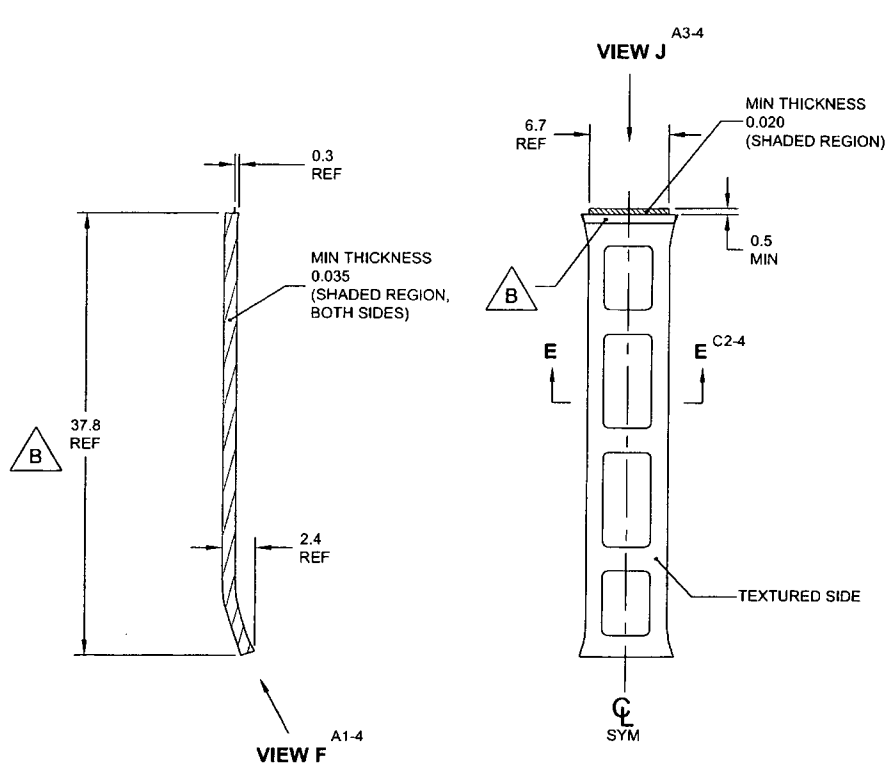
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

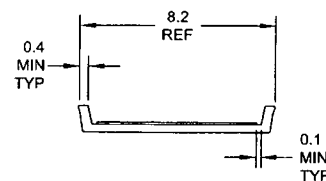
D

C

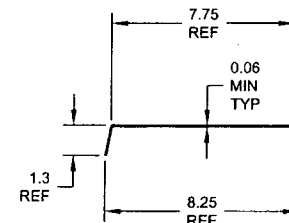
B



D3822-3 VERTICAL TUNNEL, AFT CENTER
(BELL 206 A/B)



VIEW J
SCALE 2X



VIEW F
SCALE 2X
(ROTATED 90° CW)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PA	DART AEROSPACE LTD
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA
CHECKED	PA	DRAWING NO. D3822
MFG. APPR.	PA	REV. C
APPROVED	PA	SHEET 4 OF 6
DE APPR.	PA	TITLE VERTICAL TUNNEL (BELL 206 A/B)
DATE	09.05.05	SCALE NTS
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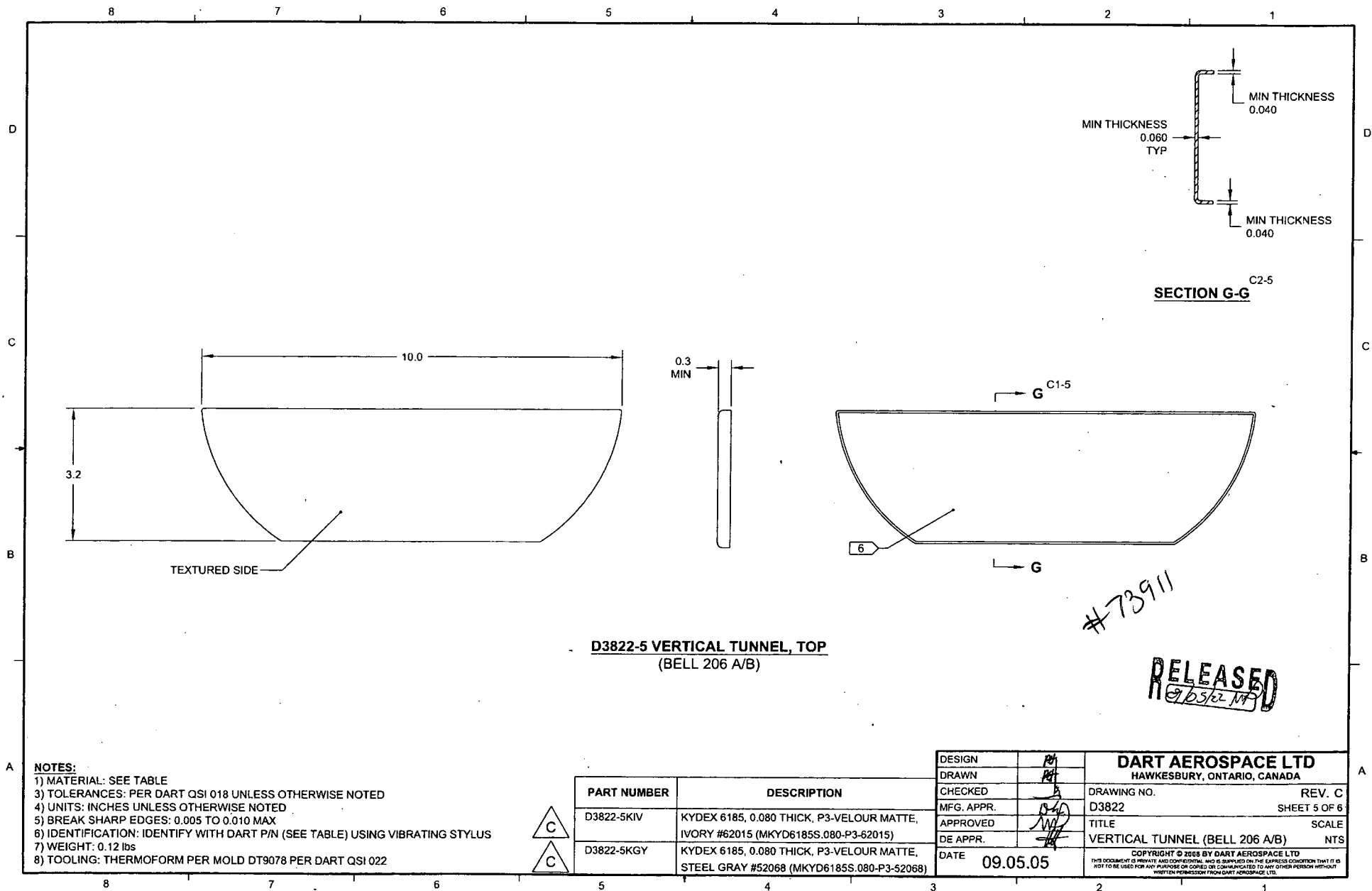
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



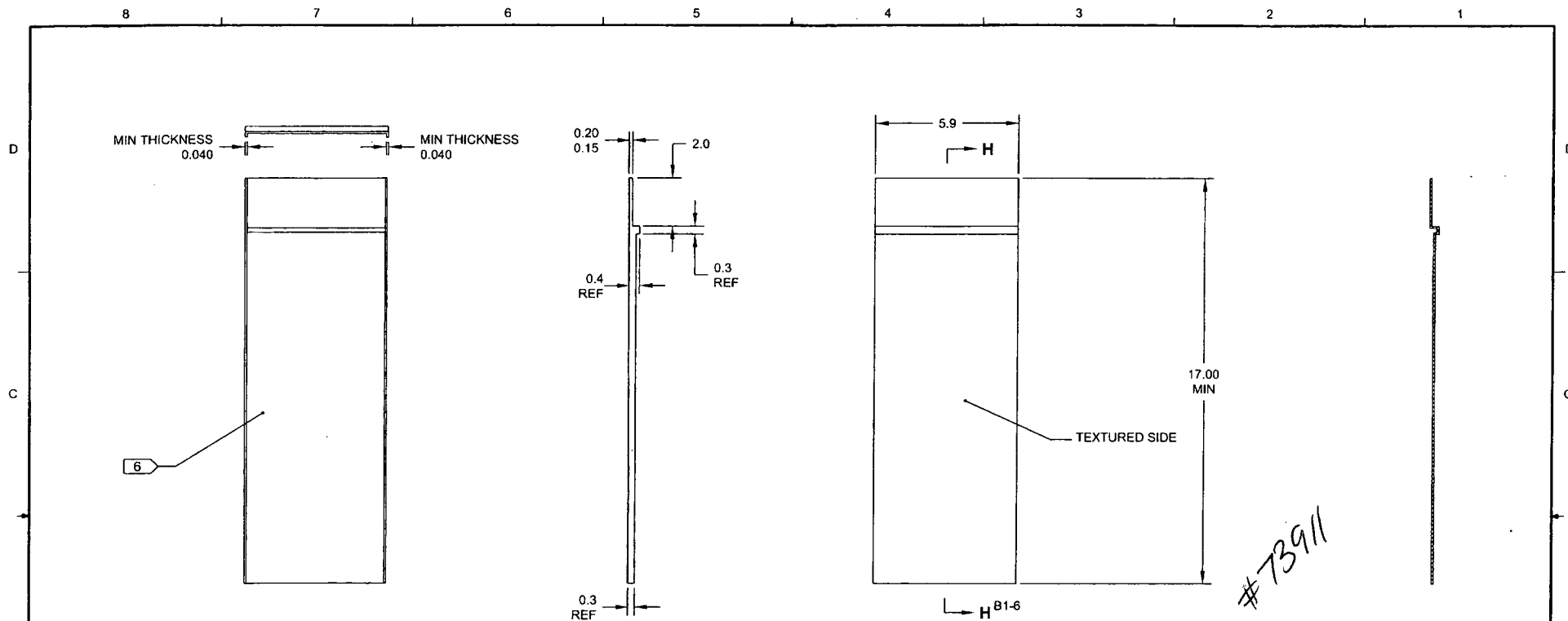
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3822-7 VERTICAL TUNNEL, LOWER
(BELL 206 A/B)

SECTION H-H B3-6

RELEASED
09/05/2005

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) WITH VIBRATING STYLUS
- 7) WEIGHT: 0.36 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022
- 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-7KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-7KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PA	DART AEROSPACE LTD
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA
CHECKED	h	DRAWING NO. REV. C
MFG. APPR.	PA	D3822 SHEET 6 OF 6
APPROVED	h	TITLE SCALE
DE APPR.	h	VERTICAL TUNNEL (BELL 206 A/B) NTS
DATE	09.05.05	COPYRIGHT © 2005 BY DART AEROSPACE LTD
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 23911
Description: Vertical Tunnel, Top		Part Number: D3822-5KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DR

Date: 11/12/21

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.3	Min	0.36 "	✓		Use DL-02	
0.040	Min	0.057 "	✓		Use DL-02	
0.060	Min	0.075 "	✓		CAL TH-01	

Measured by: DR

Date: 11/12/22

Audited by: D

Date: 4/12/22

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	<u>[Signature]</u>